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005901

8127274

646.4001

Job Sheet 184037



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No: SIOP

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	1 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs	11/9/18	11/9/18	0.00	0.00	Packaging1-1		
120	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC4		
130	Packaging	1 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs	11/9/18	11/9/18	0.00	0.00	DC		
140	QC21-FG	1 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

OCT 15 2018
Sign-off

NOV 08 2018

NOV 08 2018

NOV 13 2018

NOV 13 2018

DAS

21

9-89

NOV 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	503/229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5078331
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5079132
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5078164
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5066985
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5079498
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	511183
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5104453
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5050453
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049469
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5063766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5035790
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5050290
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802

CONTAINER NO.



AS350 Cable Cutter System

PART NO: 646.4001

Serial No/Batch: S127274

Revision:

Operation: Packaging

Change No:

Mfg Date: 11/13/18

Job No: 184037

#4. J05 1840 37

646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5063754
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5057883
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5118739
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5073258
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5083586
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5041250
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5083591
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5041498
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5056998
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5063624
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5118480
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5098034
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5048376
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5098032
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5056462
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5000063
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5095480
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048402
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5080637
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5065262
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5065264
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5116954
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5074204
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	7153848
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	71134062
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	7124089
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	7123425
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5100409
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5094592
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5094597
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5103943
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5065341
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5080642
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5050050
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5016508
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5071834
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5006921
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5115626
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5071413
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5000680
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5037684
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5103666
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5075330
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5083558
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5100408
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	280	0
	600.0990	1	12	0
	600.0991	1	12	0
	600.1012	1	14	0
	600.1013	5	34	0
	646.2910	1	27	0
	646.3001	1	5	0
	646.3110	1	3	0
	646.3210	1	16	0
	646.3301	1	8	0
	646.3510	1	19	0

646.3511	1	24	0
646.3610	1	24	0
646.3710	1	50	0
646.3711	1	34	0
646.3712	1	22	0
646.3713	1	17	0
646.3714	1	23	0
646.3715	2	33	0
646.3716	1	40	0
646.3717	1	26	0
646.3718	2	44	0
646.3719	2	36	0
646.3810	2	8	0
646.3811	1	31	0
646.3812	2	2	0
646.3813	1	13	0
646.3910	4	33	0
646.3911	1	23	0
646.3912	4	30	0
646.3913	1	39	0
646.9410	1	101	0
647.0112	2	108	0
647.7703	2	1	0
650.9201	2	17	0
AN3-11A	10	219	0
AN3-12A	2	108	0
AN3-13A	1	103	0
AN3-3A	4	293	0
AN3-4A	10	431	0
AN3-5A	2	290	0
AN3-6A	2	206	0
AN316C4R	2	43	0
AN44-5A	2	33	0
AN4C7A	2	149	0
AN665-34R	2	35	0
CCR264SS3-02	36	429	0
CR3213-5-3	14	286	0
MS20426AD5-7	2	1,061	0
MS20470AD5-5.5	8	237	0
MS20470AD5-6	8	1,022	0
MS20470AD5-7	3	146	0
MS21042L08	2	2,540	0
MS21042L3	63	3,017	0
MS21042L4	2	3,955	0
MS21047-3	18	536	0
MS24693-C278	5	154	0
MS24694-S51	5	123	0
MS24694-S54	2	36	0
MS24694-S55	3	204	0
MS27039-08-13	2	197	0
MS27039-1-10	2	214	0
MS27039-1-12	6	123	0
MS27039-1-16	24	543	0
MS27039-1-19	22	277	0
MS27039-1-20	2	117	0
MS27039-1-21	4	122	0
NAS1149F0332P	144	3,011	0
NAS1149F0363P	2	586	0
NAS1149F0432P	4	1,226	0
NAS1149FN832P	4	3,526	0

Part Specifications

Specifications could not be found.

REFERENCE ONLY

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE EXPLICIT WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.

NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

	5		5	3	78	601.3875	SCREW		UNINCORPORATED ECN(S)	
	1		1	1	77	646.9410	SHIM		UNINCORPORATED ECN(S)	
			4	4	76	601.2764	WASHER		UNINCORPORATED ECN(S)	
			2	2	75	601.2973	LOCKNUT		MS21042-08	
			2	2	74	601.2988	SCREW		MS27039-0813	
			2	2	73	601.2943	LOCKNUT		MS21042-5	
			2	2	72	601.3128	NUT		AN316C4R	
			2	2	71	601.3209	LOCKNUT		MS21042-8	
			4	4	70	601.2638	WASHER		UNINCORPORATED ECN(S)	
			2	2	69	601.2669	BOLT		AN4C7A	
			2	2	68	601.3119	CLEVIS		AN665-34R	
			2	2	67	601.3121	EYE BOLT		AN44-5A	
			2	2	66	650.9201	EYE BRACKET ASSY			
		REF	REF	REF	65	647.5701	GPS MOUNT KIT		UNINCORPORATED ECN(S)	
				2	64	601.3151	WASHER		UNINCORPORATED ECN(S)	
			2		63	601.2911	SCREW		MS24694553	
			24	24	62	601.2637	SCREW		MS27039-1-16	
	2		2	2	61	601.2763	BOLT		AN3-12A	
			1	1	60	646.3913	SHIM			
			4	4	59	646.3912	SHIM			
			1	1	58	646.3911	SHIM			
			4	4	57	646.3910	SHIM			
			5	5	56	600.1013	PRIMER			
		8 FT		8 FT	55	600.0129	VHB TAPE			
		1	1	1	54	600.1012	SEALANT		PR-105-CLASS B	
			1	1	53	600.0991	MAGNOBOND 6398 PART B		UNINCORPORATED ECN(S)	
			1	1	52	600.0990	MAGNOBOND 6398 PART A		UNINCORPORATED ECN(S)	
	6		10	10	51	601.2826	BOLT		AN3-11A	
			2		50	646.3814	WIPER BRACKET			
			2		49	601.2910	SCREW		MS27039-1-18	
		2		2	48	601.1365	SCREW		MS27039-1-10	
		2		2	47	646.3719	DOUBLER			
			2		46	646.3718	CUSTOM WASHER			
		1		1	45	646.3717	DOUBLER			
		22	2	22	44	601.1948	SCREW		MS27039-1-19	
		2		2	43	601.1952	SCREW		MS27039-1-20	
		4		4	42	601.1956	SCREW		MS27039-1-21	
400b	400c	400d	400e	400f	400g	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REFERENCE UNIT 1

REFERENCE UNIT 2